

Work Order ID 67826 - 1

Thursday, March 31, 2011 1:19:16 PM



Page 1

Item ID: D2230-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 3/31/2011 Start Qty: 100.00

Required Date: 4/15/2011 Req'd Qty: 100.00

SPV 15



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *CZ*

Date: 11/03/31

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D2230

Rev G

100



Bandsaw

Jeaspa Bandsaw

BAND SAW

0.00

Memo

0.00

Cut D2423 extrusion to 0.82"

Batch

cut @ meter

CZ 11/03/31 100

110



HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

0.00

1-Machine per folio FA927

DWG REV

FOLIO REV

(Check for crack while loading into the machine)

2- deburr rough edges

P/O 13764

issue P/O to meter

machine as per dwg D2230 REV-G

CZ 11/03/31 100

Work Order ID 67826

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Page 2

Item ID: D2230-1

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Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 3/31/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC
Quality Control

QC2- Inspect parts off machine FAX FAX

0.00

Memo

0.00

add + inspect for transit damage
attached CAFE to 6310

4/7/27 (15)

130



QC
Quality Control

QC2 Inspect parts - second check

0.00

Memo

0.00

8/11/05/02

(+15)

140



Hand Finish
Hand Finishing

Chemical Conversion Coat per QSI005 4 1

0.00

Memo

0.00

7/11/05/02 m.k.

(15x)

Work Order ID 67826

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Page 3

Item ID: D2230-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug

Start Date: 3/31/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 100.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

IS d 11/05/04

160

White Gloss(Ref:4 3.5.1) per QSI005 4 3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME

OVEN TEMPERATURE

FINISH TIME

9:15
320°F
9:45

md 11/05/05

ISX

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

IS d 11/05/05

Work Order ID 67826

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Page 4

Item ID: D2230-1

Accept

Revision ID:

Item Name: Lug

Start Date: 3/31/2011 Start Qty: 100.00

Required Date: 4/15/2011 Req'd Qty: 100.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

180

Identify as per dwg & Stock Location: *ST476*

0.00

Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

JS 11/05/06 (15)

11/5/90

11-05-6 (15)

Picklist Print

Thursday, March 31, 2011 1:19:12 PM

Page 1

Work Order ID: 67826

Parent Item: D2230-1

Parent Item Name: Lug



Start Date: 3/31/2011

Required Date: 4/15/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP ID 00,11,01 : Added inspection level 8, and removed P/O for powder coat ECI

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423		Manufactured	No			110	f	384,5000	0 0683	7.189474			



Lug Extrusion



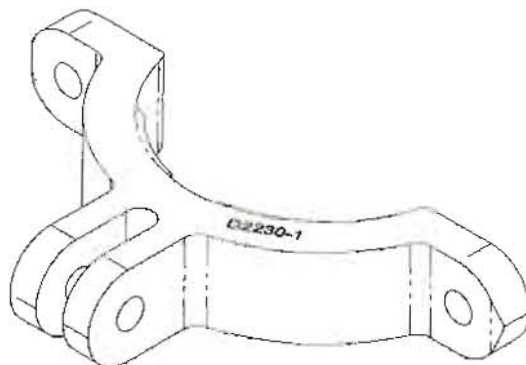
Location	Loc Qty	Loc Code
MAT006	384 5	
43722	161 5	
45800	1	
63005	222	

7.19

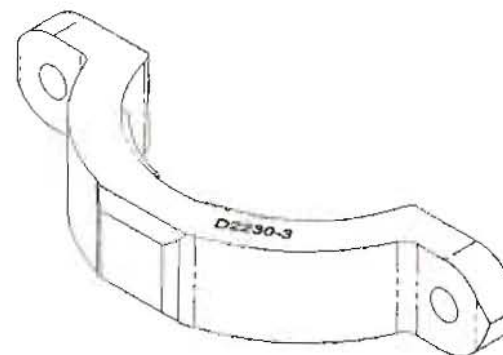
D2230-1P

X100

4/4/27 (15)



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

RELEASED
01/03/11

C211/03/31

W10: 67826

DESIGN	BW	DART AEROSPACE LTD MAWKEBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG APPR		D2230	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DES APPR		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1999 BY DART AEROSPACE LTD	

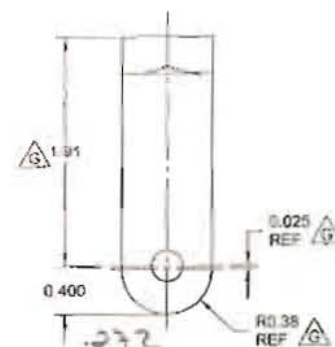
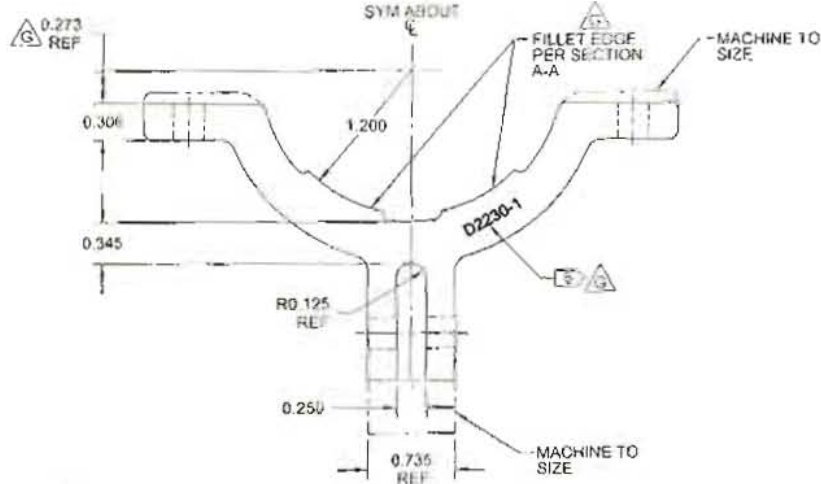
NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 \pm 0.005
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

SECTION A-A (D4-2)
SCALE 2X



R0.05 MIN - R0.10 MAX
2 PL



W10.61826

D2230-1 MOUNTING LUG

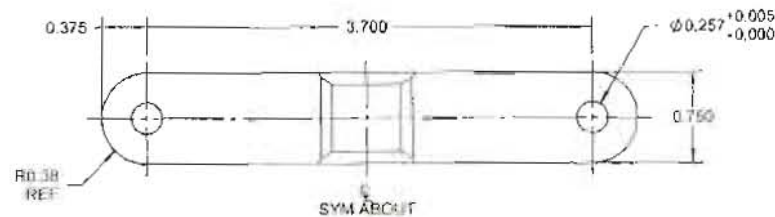
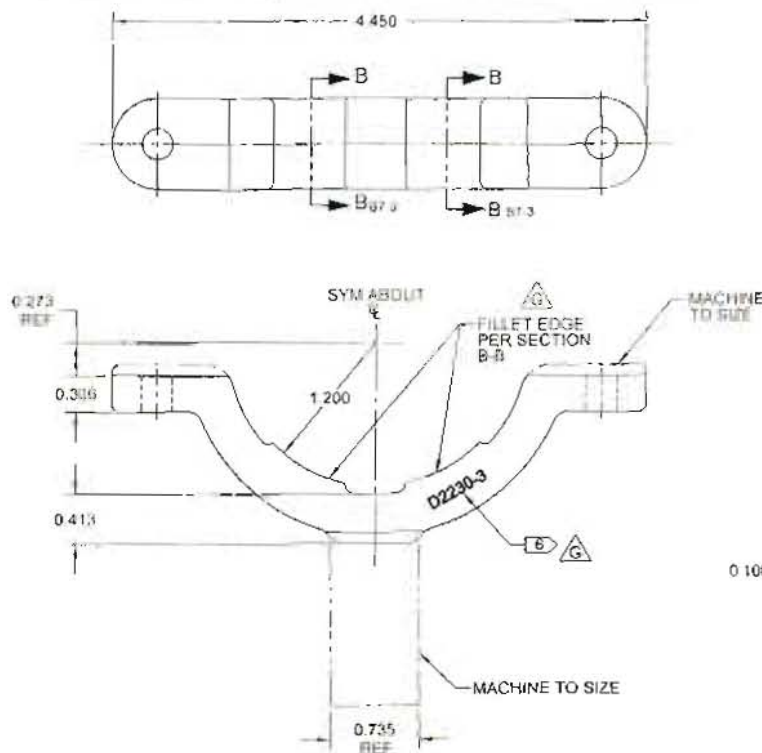
RELEASED
01/06/75

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO	REV. G
MFG APPR		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1984 BY DART AEROSPACE LTD	

SECTION B-B
SCALE 2X



R0.08 MIN - R0.10 MAX
2 PL

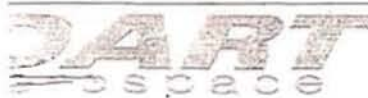


D2230-3 MOUNTING LUG

W10.678.26

RELEASED
01/04/2010

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG APPR		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR		MOUNTING LUG	NTS
DATE	09.01.16	<small>Copyright © 1994 by DART Aerospace Ltd. All rights reserved. No part of this drawing may be reproduced or transmitted in any form or by any means electronic or mechanical, including photocopying, recording, or by any information storage and retrieval system, without permission in writing from DART Aerospace Ltd.</small>	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO13764

Purchase Order Date 3/31/2011

PO Print Date 4/6/2011

Page Number 1 of 1

Order From: VC-MET003

IETEC METAL TECHNOLOGY INC.
10 TERRY FOX DRIVE PO BOX 781
WANKLEEK HILL, QC K0B 1R0
CANADA

Contact Name	Buyer	Chantal Lavigne
Vendor Phone 613 678 3957	Requisition Nbr	
Vendor Fax 613 678 3956	Tax Resale Nbr	10127-2607
Vendor Account Nbr	Terms	Net 30
	Currency	CAD
	FOB	Destination-Collect

REVISED

Order To: DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Shr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
	D2230-1P	LUG	4/22/2011 Yes	100.00 Each	Dart Truck Net 55	\$18.9500	\$1,895.00
		Special Inst:	MACHINE AS PER DWG D2230 REV. G B67826				
	D2230-3P	LUG	4/22/2011 Yes	100.00 Each	Dart Truck Net 55	\$13.6000	\$1,360.00
		Special Inst:	MACHINE AS PER DWG D2230 REV. G B67827				
	D3235-1P	lug	4/22/2011 Yes	100.00 Each	Dart Truck Net 85	\$15.0500	\$1,505.00
		Special Inst:	MACHINE AS PER DWG D3235 REV. A B67831				

PO Total: \$4,760.00

CL

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 2

Change Date: 4/6/2011



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 17926
Date: Apr 26, 2011
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 13764	Sold By:
Shipped By: your truck	Ship Date:

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1 Mounting Lug Material supplied by DART: D2423 B63005	Each	100	15	
D2230-3 Mounting Lug Material supplied by DART: D2423 B63005	Each	100		
D3235-1 Mounting Lug Material supplied by DART: D2423 B63005	Each	100		
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
15	D2230-1	Lug	13764

MATERIAL: supplied by DART D2423 B63005

8/10/05/02

We hereby certify that the above parts were made in conformance with applicable drawings

METEC Metal Technology Inc

Shigi Walz
Shigi Walz

Vankleek Hill, April 26, 2011